

Order ID 118823

3:27:47 PM

118823

Page 1

Item: 646.3711

646.3711

Accept

N900040100

Setup Start *NS1*

Revision ID:

B118823

Item Name: Clip

Stop *NS2*

Start Date: 6/13/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 14-05-06

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

646.3700

A

110

0.00

110

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

DAS
20
9-89

(12)

(1)

14/06/06

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

Quality Control

0.00

DAS
20
9-89

(12)

(1)

14/06/06

PTC

Work Order ID 118823

118823

Page

May-05-14 3:27:47 PM

Item ID: 646.3711

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clip

Start Date: 6/13/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00 DAS 27 9-89 14/6/10				12			
140 *140* Brake NC Brake NC	Form as per dwg Memo	0.00 0.00 DAS 30 9-89				12			14/6/10
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 DAS 27 9-89 14/6/10				12			

Work Order ID 118823

118823

May-05-14 3:27:47 PM

Item ID: 646.3711

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Clip

Stop *NS2*

Start Date: 6/13/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

155

155

HandFinish

Hand Finishing

Memo

CLEAN AND REMOVE ALL MARKINGS

0.00

N/A done @ ATG

CL 14/07/07

160

160

Outsource4

Outsource process - Anodize

Outsource process-Anodize per QSI017 4.1.10.1

0.00

Memo

Issue P/O to ATG :

24896

0.00

1- Black Anodize as per Dwg 646.3700

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Comformity is required

CL 14/07/07 12

170

170

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

CL 14/11/03 (12)

Work Order ID 118823

118823

Page 4

May-05-14 3:27:47 PM

Item ID: 646.3711

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clip

Start Date: 6/13/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

DAS
27
9-29
14/1/23

12

210

Identify as per dwg & Stock Location:

0.00

210

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

S#10 CCH/1.3

14/7/23 12

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLJ 14-07-24

4-7-24

Picklist Print

May-05-14 3:27:49 PM

Page 1

Work Order ID: 118823

118823

Parent Item: 646.3711

646.3711

Parent Item Name: Clip

Start Date: 6/13/14

Required Date: 6/13/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.11.23 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		110	sf	646.6080	0.036	0.378947			

M6061T6S 063

6061-T6 .063 Sheet

mm 14/06/06

Location

Loc Qty

Loc Code

MAT021

646.608

M124446

9

M126075

4.5

M127006

9

M127420

132.62

M128054

171.488

M128941

320

0.6

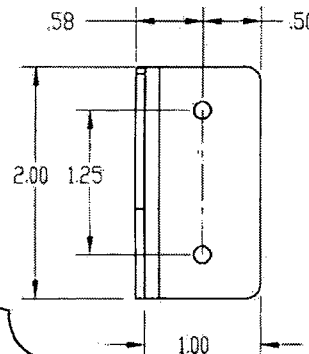
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03702				SHEET 1 OF 2	
	DWG NO. 646.3700	REV: A	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: SHEETMETAL					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: ADDED ALTERNATE MATERIAL AND REVISED REFERENCE DIMENSIONS			EOR: D-12-010	

SHEET 1, ZONE A2 IS:

IS

△ PRIMARY MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
ALTERNATE MATERIAL: SS 17-4 PH PER AMS 5604

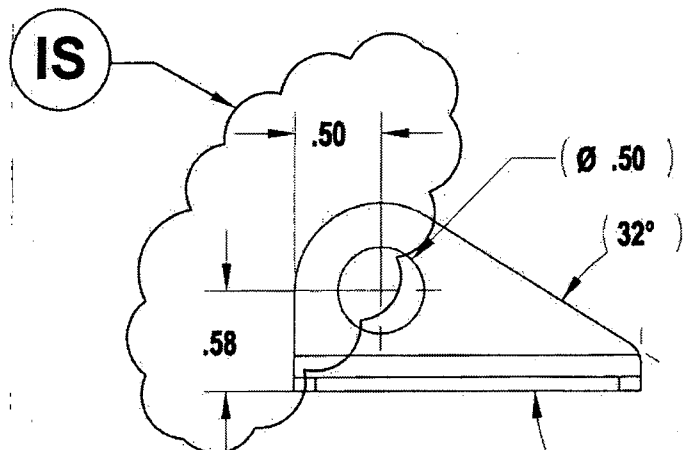
IS



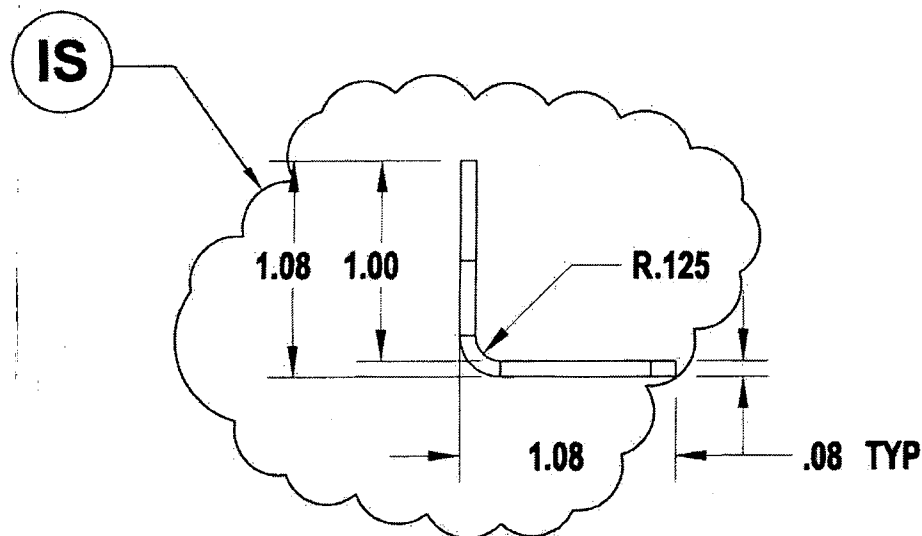
SHEET 7, ZONE B1 IS:

118823 MJS
14-0506

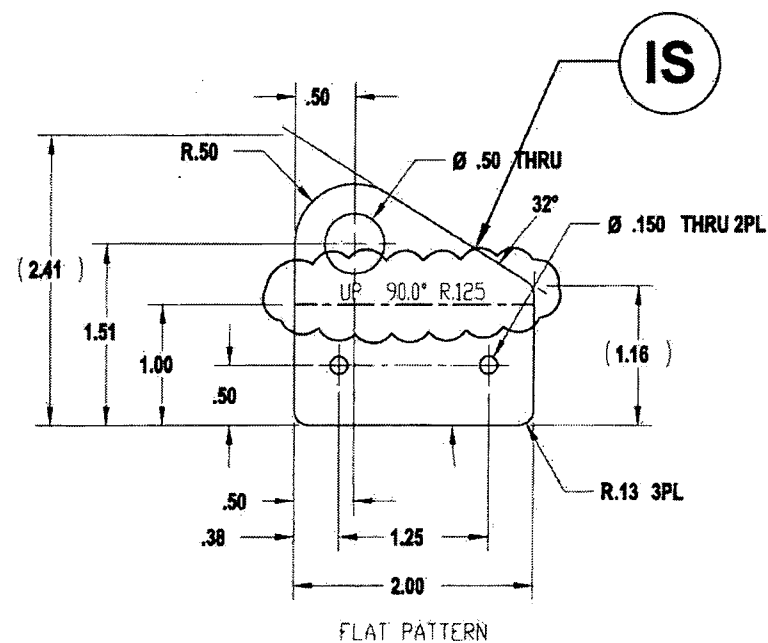
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO



SHEET 7, ZONE C4 IS:



SHEET 7, ZONE D1 IS:



SHEET 7, ZONE B7 IS:

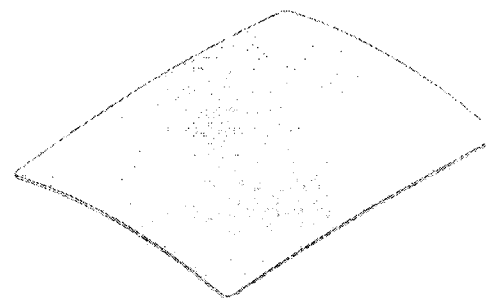
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-----	----	-------------	-----	-------------	------------------------

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REV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 03702	11/06/07	TS

NOTES:

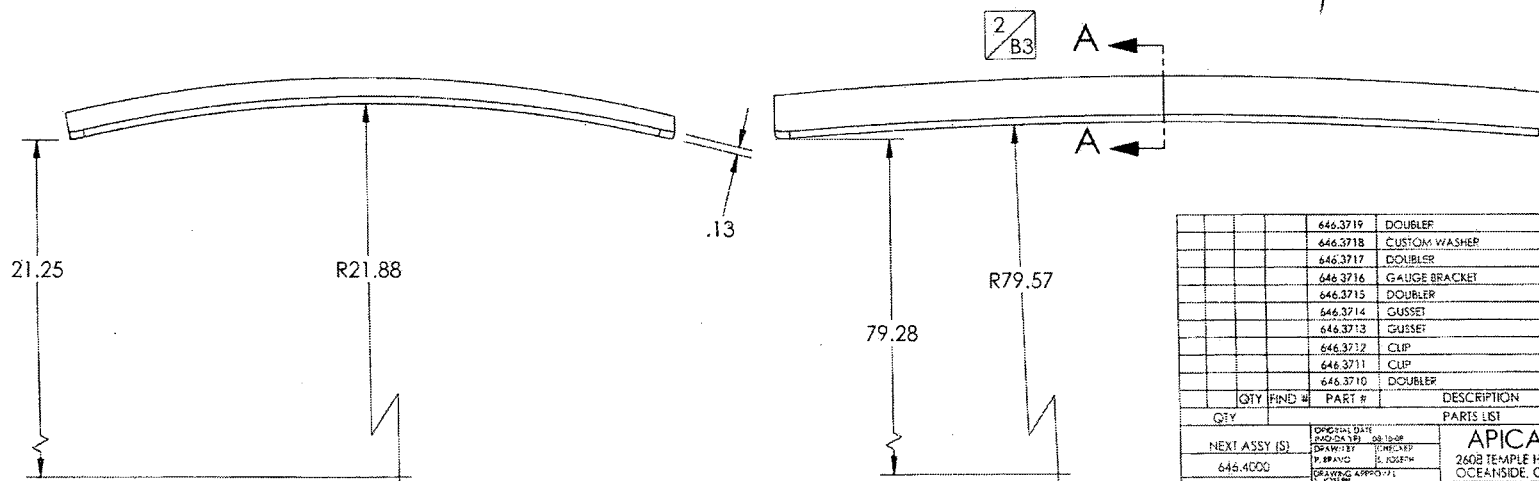
1. MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER IAW MIL-P-23377J TYPE I CLASS N
3. MATERIAL: 17-4 PH AMS 5604, CONDITION H900
4. FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

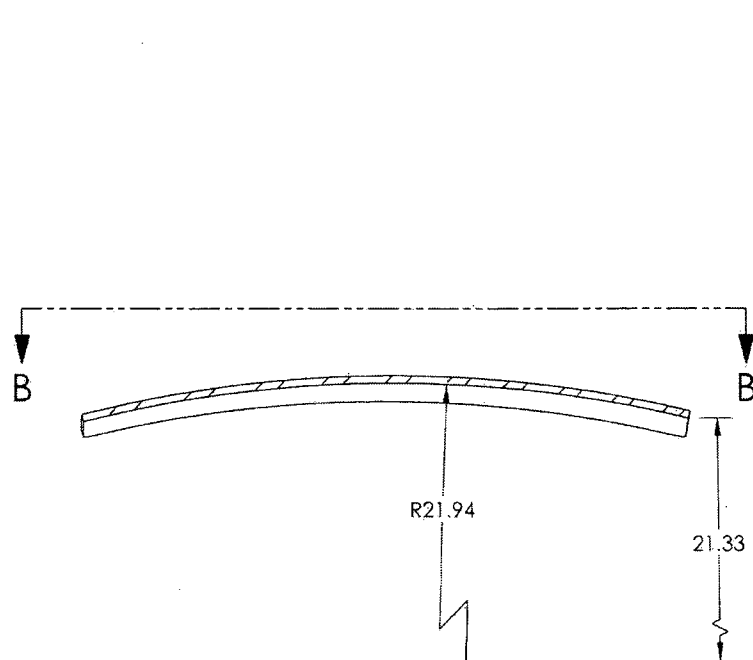
UNINCORPORATED ECN(s)

03702



QTY	PNL	PART #	DESCRIPTION	MATL	SPEC.
		646.3719	DOUBLER	△	△
		646.3718	CUSTOM WASHER	△	△
		646.3717	DOUBLER	△	△
		646.3716	GALUGE BRACKET	△	△
		646.3715	DOUBLER	△	△
		646.3714	GUSSET	△	△
		646.3713	GUSSET	△	△
		646.3712	CLIP	△	△
		646.3711	CLIP	△	△
		646.3710	DOUBLER	△	△
PARTS LIST			APICAL INDUSTRIES		
NEXT ASSY IS:			2608 TEMPLE HEIGHTS DR.		
646.4000			OCEANSIDE, CA. 92056-3512 (760)724-5300		
			SHEETMETAL		
			SRC 1CAGAC007	DWG NO. 646.3700	REV. A
			B 1 07/11/16		
			SCALE: NONE	SHEET 1 OF 9	

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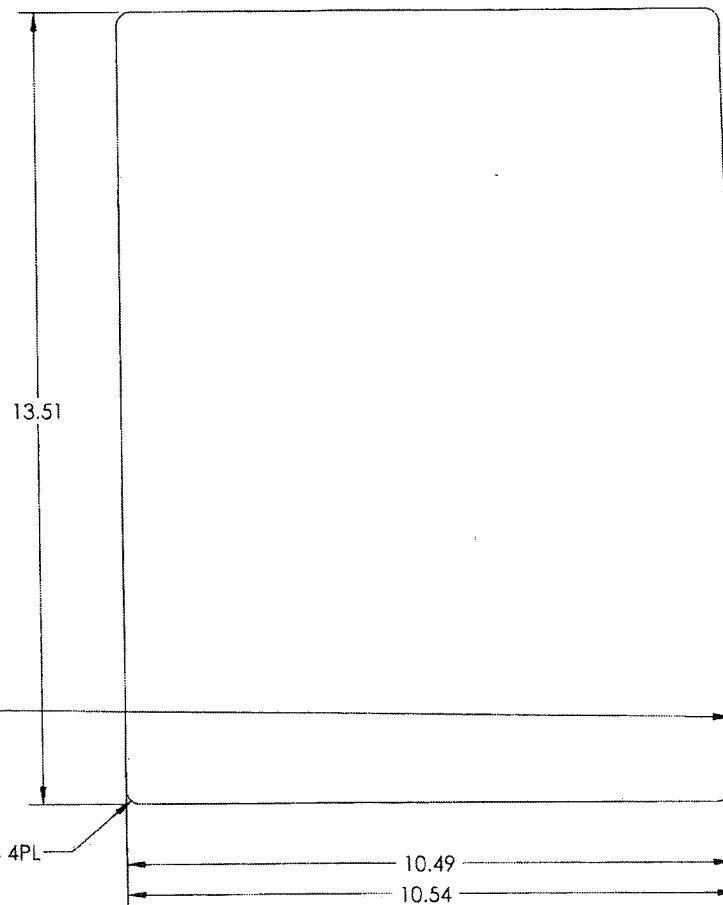


SECTION A-A



R395.138

R.13 4PL

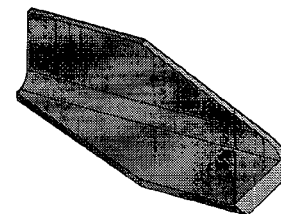
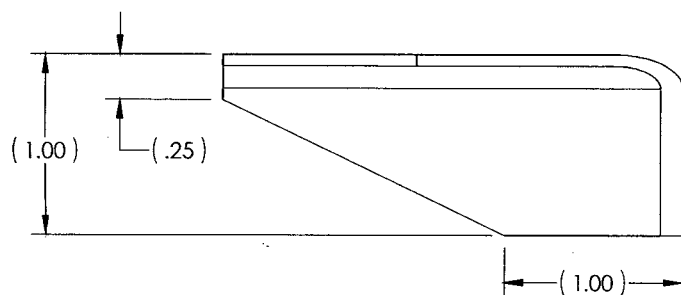


SECTION B-B

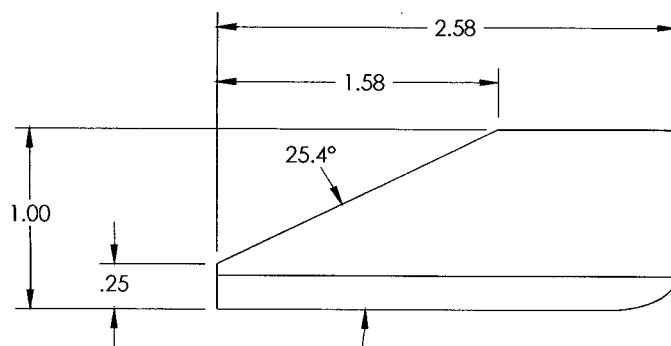
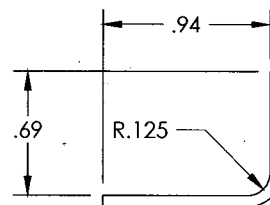
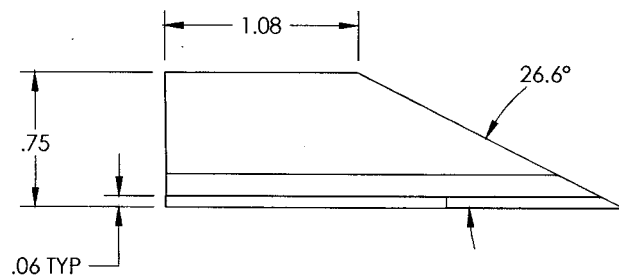
ORIGINAL DATE: 06-15-08 DRAWN BY: C. CHAFFIN P. BRAND: J. JOSEPH		APICAL INDUSTRIES 2605 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL: J. JOSEPH C. CHAFFIN		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DECIMALS ARE: 1 PLACE DECIMALS ± 0.1 2 PLACE DECIMALS ± 0.05 ANGLES ± 5°		PART CODE: B DATE: 07/1/06 SCALE: NONE	DRAWING NO: 646.3700 REV: A SHEET: 2 OF 9

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



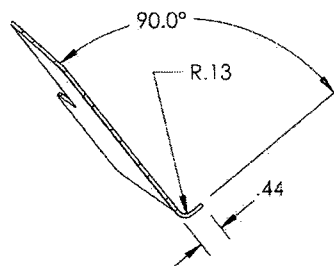
646.3711 SHOWN
646.3712 OPPOSITE



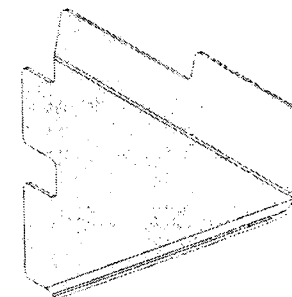
NEXT ASSY (S)	ORIGINAL DATE (DRAWN-YR)	06-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY	CHECKED		
	P. BRAVO	S. JOSEPH	SHEETMETAL	
	DRAWING APPROVAL			
	S. JOSEPH		SEE CAGE CODE DWG. NO. 646.3700 REV. A	
	06-18-08			
	CONTRACT NO.		SCALE: NONE SHEET 3 OF 9	
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			

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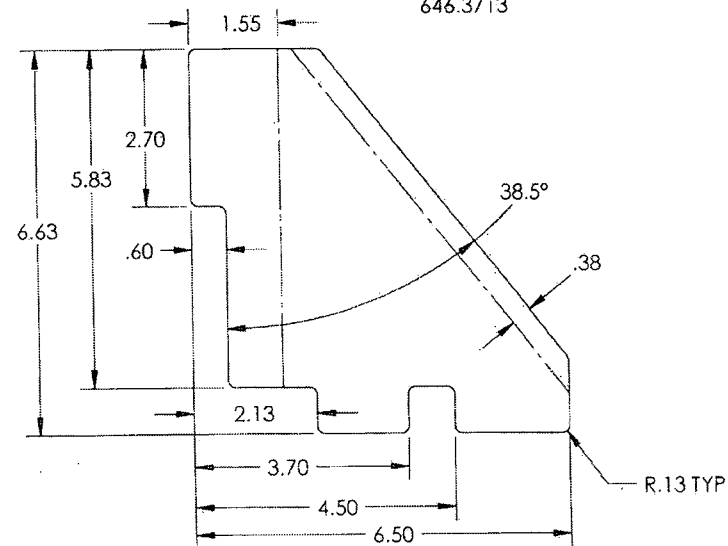
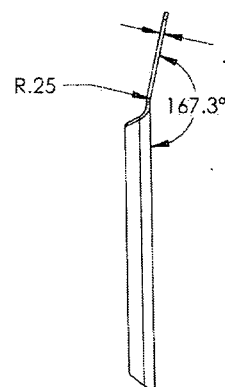
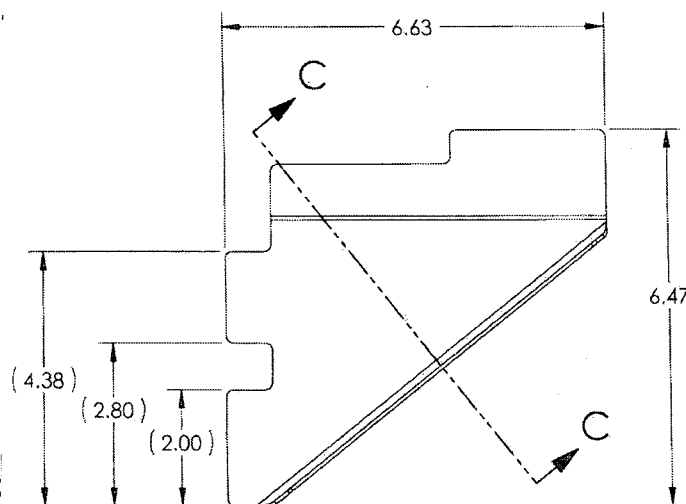
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



SECTION C-C



646.3713

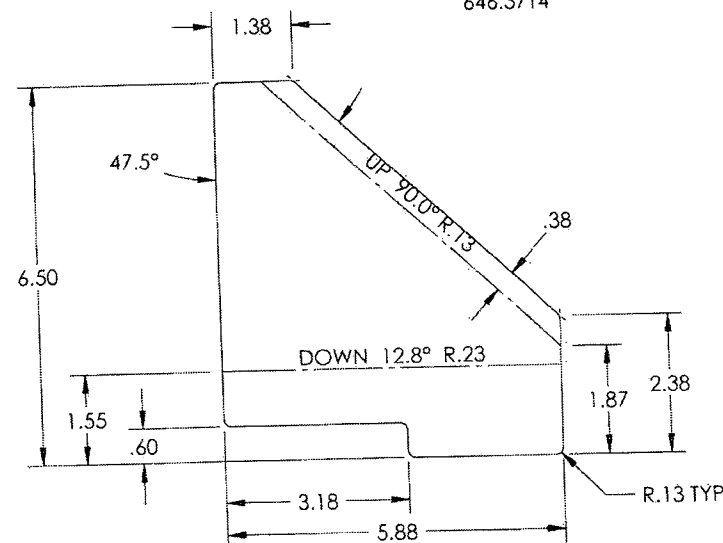
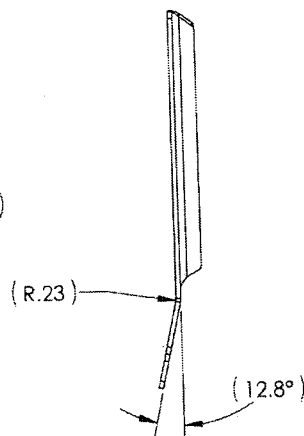
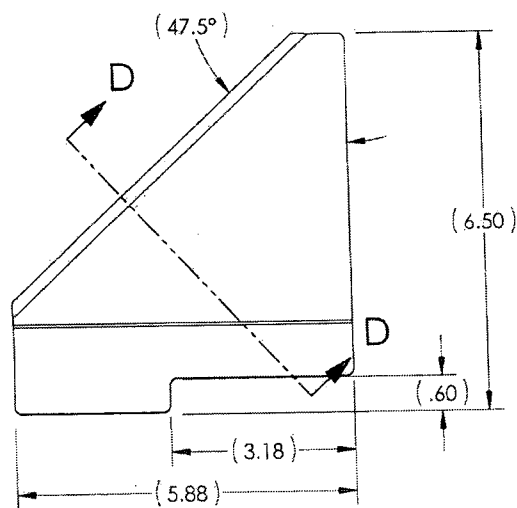
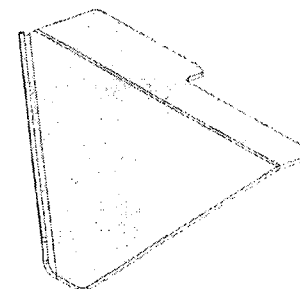
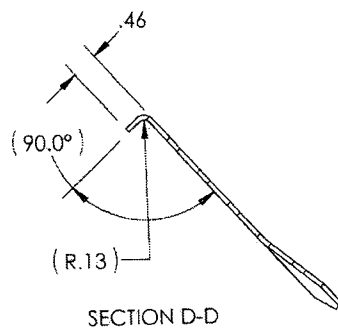


FLAT PATTERN

NEXT ASSY IS	ORIGINAL DATE 08-18-06		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
	DRAWN BY J. JONES			
	CHECKED BY J. JONES			
	DATE 08-18-06			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS ARE UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS ARE			SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS ARE			SHEET 4 OF 4	REV A

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REV.	DESCRIPTION	DATE	APPROVED

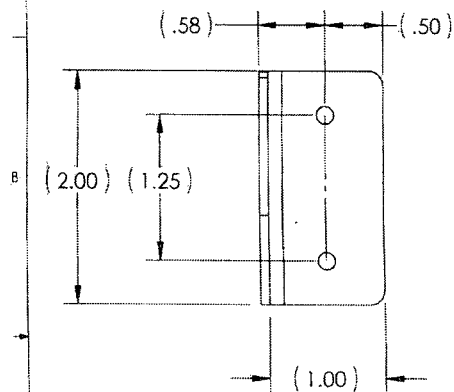


ORIGINAL UNIT
INCHES
DRAWN BY: J. J. JONES
CHECKED BY: J. J. JONES
DATE: 07/17/76
SCALE: NONE

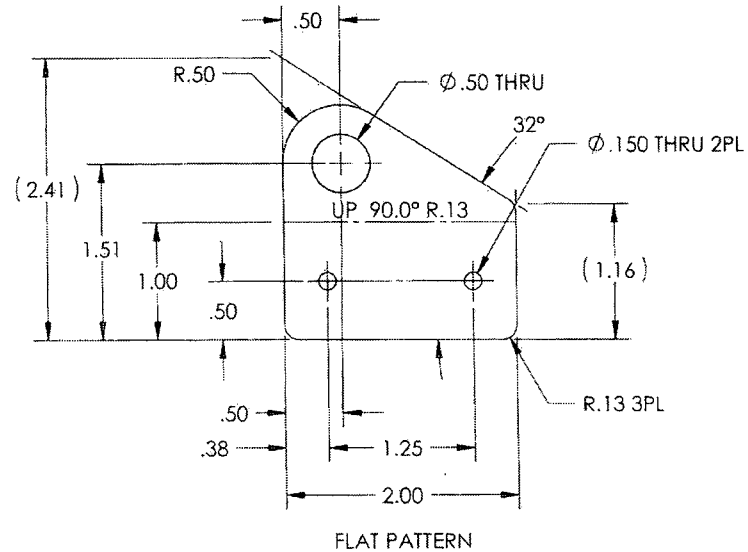
APICAL INDUSTRIES
2609 TEMPLE HEIGHTS DR.
OCEANSIDE, CA 92056-3512 (760) 724-5300
SHEETMETAL
646.3700
SHEET 5 OF 9

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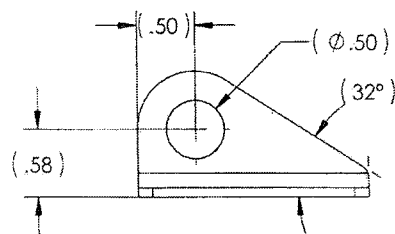
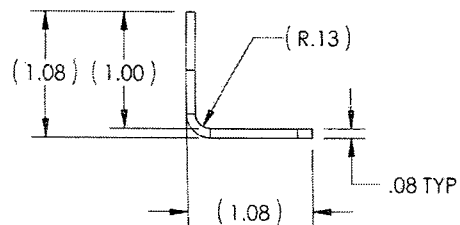
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



646.3716



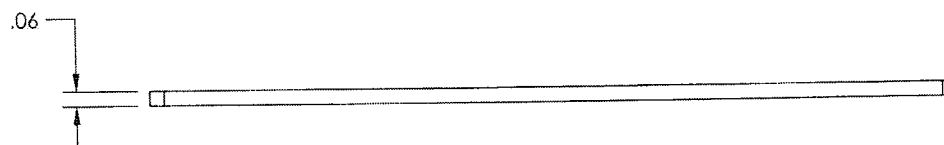
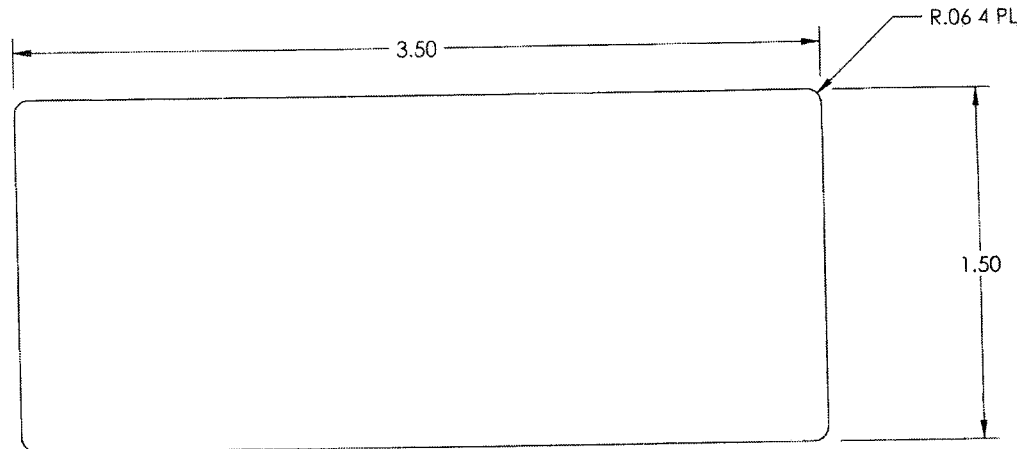
FLAT PATTERN



NEXT ASSY (S)	ORIGINAL DATE 06-15-08		APICAL INDUSTRIES	
	DRAWN BY: CIRCLES		2608 TEMPLE HEIGHTS DR.	
	P. 8TH FLOOR		OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWING APPROVAL		SHEETMETAL	
	DATE: 06-15-08			
	CONTRACT NO.			
	UNLESS OTHERWISE SPECIFIED		SHEET CODE: 646.3700	
	DIMENSIONS ARE IN INCHES		REV A	
	TOLERANCES ARE:		SCALE: 1:1	
	FRACTIONS DECIMALS		SHEET 7 OF 9	
	ANGLES: 1° 5'			

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REVISION			
REV.	DESCRIPTION	DATE	APPROVED



646.3717

NEXT ASSY (S)	ORIGINAL DATE (BY MONTH)	08-18-08	APICAL INDUSTRIES 2638 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY	P. BRAVO		
	DESIGNED BY	J. JOSEPH		
	CONTRACT NO.			
	DRAWING APPROVAL		SHEETMETAL SEE BACK COVER DWS NO 646.3700 REV. A SCALE: 1"=1'-0" SHEET 80" x 9"	
	UNLESS OTHERWISE SPECIFIED			
	DIMENSIONS ARE IN INCHES			
	2 PLACE DECIMALS 1/16"			
	3 PLACE DECIMALS 1/32"			
	4 PLACE DECIMALS 1/64"			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: dat Date: 14/08/01QA Closed: dat Date: 14/17/28

Work Order: <u>118823</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>646,3711</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-4081</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator	<u>14/6/06</u>	<u>110</u>	<u>①</u>	measurements were off hole was oval.	<u>DAS 16 9-89</u>	changed Radius. changed type of hole in program	<u>mm</u> <u>14/06/06</u>	<u>DAS 27 9-89</u> <u>14/6/06</u>	<u>DAS 27 9-89</u> <u>14/6/06</u>
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input checked="" type="checkbox"/> Other
		<u>Reset program on tool</u>
		<u>dimension</u>



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
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Pack List

Number: 63165

Date: 23-Jul-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	
1 lot	Part: ASST 12 PCS 646.3711 (6.10) 10 PCS 646.3011 (10.25) 20 PCS 647.9710 (14.50) 6 PCS 646.3310 (18.10) 10 PCS 646.3810 (6.55) 10PCS 646.3812 (6.10) 6 PCS 646.3312 (12.05) HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N 4 PCS D4703-043 (0.90) BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 PRICE IS PER PIECE Job: 20140429	Line:	
Certificate of Conformance			
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.			
ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY			
DATE : 23/7/14			
CERTIFIED SIGNATURE : 			
RECEIVER SIGNATURE : _____			